

# Work Order ID 85108

**\*85108\***

Page 1

Friday, June 01, 2012 4:04:44 PM

Item ID: PB67-43001-59

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: PB67-43001-59

Start Date: 6/1/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MC*

Date: *12-06-09*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-59

Rev C

100

0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*ll*  
*12-06-13*

*BB 12-06-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: PB67-43001-59

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Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: PB67-43001-59

Start Date: 6/1/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*120\***

QC

Memo

Quality Control

130	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*130\***

HandFinish

Memo

Hand Finishing

140	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*140\***

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30  
320°F  
3:00

W18144

1 2/6 24/5

1X 12/06/18

W/O:		WORK ORDER CHANGES					
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Revision ID:

Stop **\*NS2\***

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Start Date: 6/1/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

1  $\phi$  BLD-2-18

160

Small Fab

0.00

**\*160\***

Small Fab

Memo

0.00

Small Fab

1- take -267 and transfer drill holes in -113 as per dwg PB67-430012- deburr  
and rivet -267 to -113 as per dwg3- assemble rest of parts as per dwg PB67-  
430011  $\phi$  Ae  
12.06.20

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

8/17/04/20

1  $\phi$  Ae  
12.06.20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

Identify as per dwg & Stock Location: 431

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

4/2/12/20 (1)

12/6/26 JF  
MK  
12-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 85108

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:A 08-07-18 new issue DD verified by:ec  
 IPP Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified by: eC IPP RevC  
 10.09.29 per revC dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
\ PB67-43001-121 Square Sleeve		Manufactured	No			160	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST445		4							
\ PB67-43001-267 PB67-43001-267		Manufactured	No		43329	160	Each	8.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST439		8							
\ 30345T21 LANYARD		Purchased	No		44976	160	Each	37.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		37							
\ BSP43 RIVET		Purchased	No		17828	160	Each	55.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		55							
					110704	50							
					111127	5							

Ae 12.06.20

Ae 12.06.20

Ae 12.06.20

Ae 12.06.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 85108

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

\* MS17984-C413  
PIN, QUICK RELEASE

Purchased

No

160

Each

26.0000

2

2

Ac 12.06.20

Location	Loc Qty	Loc Code
ST315	3	
114340	1	
118612	2	
ST333	23	
121350	20	
121827	3	

MS21042L3

Nut

Purchased

No

160

Each

2,195.0000

2

2

Ac 12.06.20

Location	Loc Qty	Loc Code
ST300	2195	
117885	32	
119017	952	
119075	138	
121349	221	
121444	852	

MS27039-1-22

SCREW

Purchased

No

160

Each

292.0000

2

2

Ac 12.06.20

Location	Loc Qty	Loc Code
ST291	136	
112940	100	
18057	36	
ST292	156	
112940	100	
18057	56	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 85108

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Washer

Purchased

No

160

Each

2,398.0000

4

4

Ac 12.06.20

## Location

## Loc Qty

## Loc Code

ST297

1000

121708

1000

ST298

1398

105793

12

110985

4

117087

89

119042

16

119717

334

120644

7

121011

936

NAS1149DN416J

Washer

Purchased

No

160

Each

113.0000

4

4

Ac 12.06.20

## Location

## Loc Qty

## Loc Code

ST297

113

114597

43

13910

70

PB67-43001-105

Plug

Manufactured

No

100

Each

0.0000

1

1

Pl 12.06.13

PB67-43001-113

Square Tube

Manufactured

No

100

Each

1.0000

1

1

Pl 12.06.13

## Location

## Loc Qty

## Loc Code

ST445

1

54626

1

PB67-43001-115

Tube End Plate

Manufactured

No

100

Each

8.0000

1

1

Pl 12.06.13

## Location

## Loc Qty

## Loc Code

ST445

8

24807

8

PB67-43001-117

Hook Plate

Manufactured

No

100

Each

0.0000

1

1

Pl 12.06.13

Friday, June 01, 2012 4:04:44 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, June 01, 2012 4:04:44 PM

Page 4

Work Order ID: 85108

Parent Item: PB67-43001-59

Parent Item Name: PB67-43001-59

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-119

Manufactured No

100 Each 1.0000

1 1

End Cap Clevis

12.06.13

Location

Loc Qty

Loc Code

ST445

1

41478

1

PB67-43001-271

Manufactured No

100 Each 13.0000

1 1

Doubler

12.06.13

Location

Loc Qty

Loc Code

ST438

13

44975

13

PB67-43001-275

Manufactured No

160 Each 0.0000

1 1

Doubler

12.06.13

B 85645

Friday, June 01, 2012 4:04:44 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

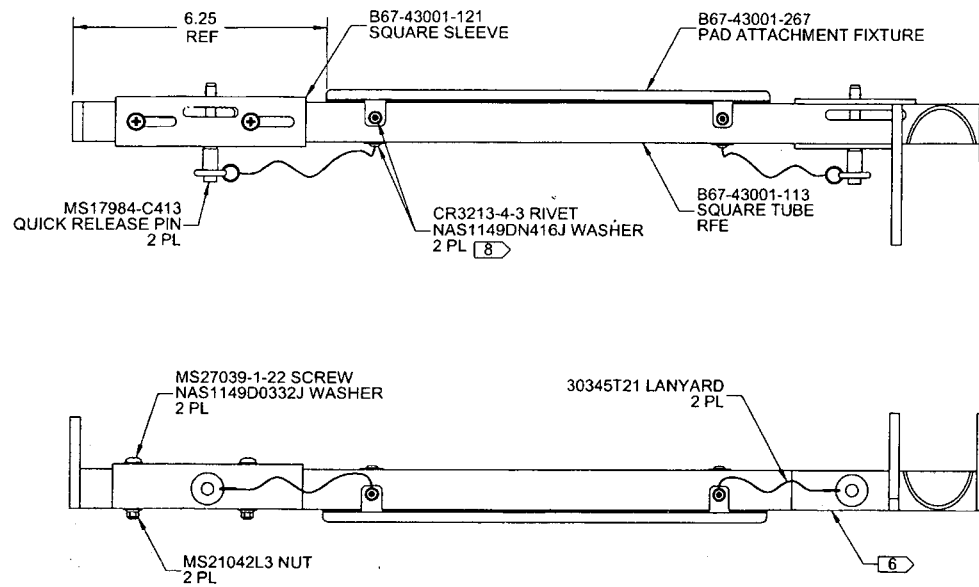
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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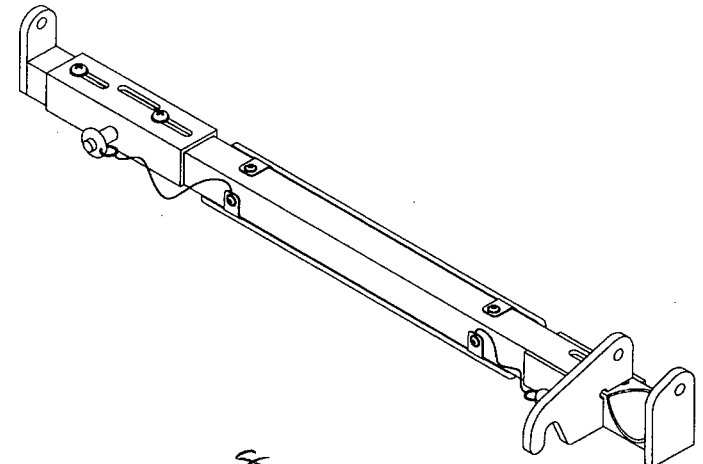
**NOTE:** Date & initial all entries



ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
3	1	B67-43001-121	SQUARE SLEEVE
4	1	B67-43001-267	PAD ATTACHMENT FIXTURE
6	2	30345T21	LANYARD
7	4	CR3213-4-3	RIVET (OR BSP43-4-3)
8	2	MS17984-C413	QUICK RELEASE PIN
9	2	MS21042L3	NUT
10	2	MS27039-1-22	SCREW
11	4	NAS1149D0332J	WASHER
12	4	NAS1149DN416J	WASHER



**B67-43001-59 ADJUSTABLE ATTACHMENT ARM**



- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-59" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 2.21 lbs
  - 8) FOLD -267 TABS OVER AND TRANSFER DRILL  $\varnothing 0.130$  FROM -267 TO -113 PRIOR TO INSTALL CR3213-4-3 RIVETS.

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 14 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.15
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS	DRAWING NO.	REV. C	
CHECKED	AS	B67-43001-59	SHEET 1 OF 2	
MFG. APPR.	AS	TITLE	SCALE	
APPROVED	AS	ADJUSTABLE ATTACHMENT ARM	NTS	
DE APPR.	N/A	DATE 09.06.15		
<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>				

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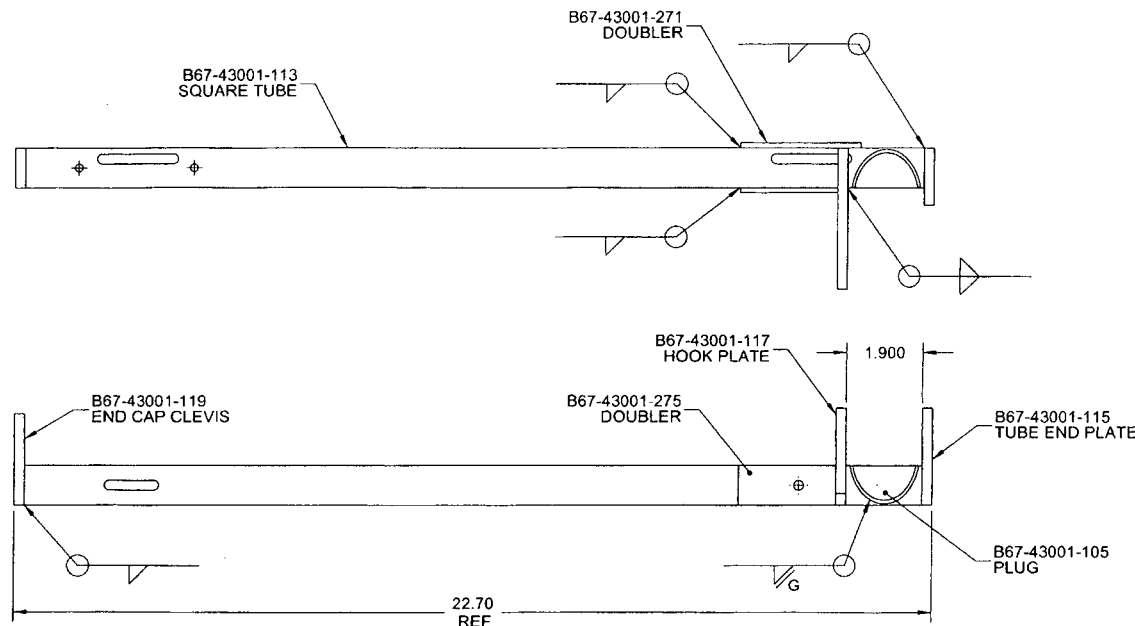
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ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59W	ADJUSTABLE ATTACHMENT ARM WELDMENT
3	1	B67-43001-105	PLUG
4	1	B67-43001-113	SQUARE TUBE
5	1	B67-43001-115	TUBE END PLATE
6	1	B67-43001-117	HOOK PLATE
7	1	B67-43001-119	END CAP CLEVIS
8	1	B67-43001-271	DOUBLER
9	1	B67-43001-275	DOUBLER



**B67-43001-59W ADJUSTABLE ATTACHMENT ARM  
(WELDING DETAIL)**

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lbs
- 8) WELDING: PER QSI 004
- 9) MASK ALL HOLES AND OPENINGS PRIOR TO POWDER COAT

DESIGN	RW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		B67-43001-59	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	N/A	ADJUSTABLE ATTACHMENT ARM	NTS
DATE	09.06.15	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2010-09-16  
JMD

85108

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